

Work Order ID 107855

Thursday, October 03, 2013 4:14:51 PM

107855

Page 1

Item ID: D3440-13

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket (Supersedes B67-43001-273)

Start Date: 10/3/2013 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MFDate: 13-10-04 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3440

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 2.00" x 2.200" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA539 and Dwg D3440Dwg Rev: A Identify as
D3440-13Folio Rev: AA Deburr

120

0.00

120

QC

Memo

0.00

Quality Control

QC2- Inspect parts off machine FAI/FAIB

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date: 13/10/23QA Closed: Date: 13/10/23

Work Order: <u>107855</u> Part No. <u>D3440-13</u> NCR No. <u>13-3157</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	08/10/18	110	1	Part scrap moved in use PL to Tooling	DAS 16 9-89 Q22412 13/10/18	Scrap Defect Rejected B 124443 \$110.96	MH/10/18 13/10/18	DAS 40 9-89 13/10/19	DAS 16 9-89 Q22412 13/10/18
Equip/Tooling									
Operator									
Material									
Setup									
Other <input checked="" type="checkbox"/>									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other <u>Tooling</u>

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Revision ID:

Stop ***NS2***

Item Name: Bracket (Supersedes B67-43001-273)

Start Date: 10/3/2013 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS
40
9-89

13/10/19

6

Ø

140

Identify as per dwg & Stock Location: MEZZ.2 0.00***140***

Packaging

Memo

0.00

Packaging

6x

DAS
28
9-89

13-10-21

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

Quality Control

DJ/Rm 13/10/21

MF
13-10-21

Picklist Print

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Work Order ID: 107855

Parent Item: D3440-13

Start Date: 10/3/2013

Required Date: 10/11/2013

Parent Item Name: Bracket (Supersedes B67-43001-273)

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A05.07.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.000 6061-T6 Bar 2.00 x 2.00		Purchased	No			100	f	16.5475	0.1833	2			

Location

Loc Qty

Loc Code

MAT009

16.5475

124443

16.5475

1.155 MH B/10/17

DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3440-13
Inspection Dwg: D3440 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
30°	+/-0.5°	30°	✓		Digital angle	—
0.40	+/-0.030	.400	✓		MH-04	Caliper
0.500	+/-0.010	.497	✓			
0.450	+/-0.010	.453	✓			
2.00	+/-0.030	2.012	✓			
0.776	+/-0.010	.776	✓			
1.06	+/-0.030	1.067	✓			
R0.875	+/-0.010	.875	✓		radius (pipe)	—
2.280	+/-0.010	2.280	✓		MH-04	Caliper
1.400	+/-0.010	1.405	✓			
1.200	+/-0.010	1.200	✓			
1.88	+/-0.030	1.890	✓			
0.563	+/-0.010	.562	✓			
0.250	+/-0.010	.250	✓			
0.250	+/-0.010	.251	✓			
Ø0.257	+0.006/-0.001	.260	✓			
Ø0.375	+0.006/-0.001	.375	✓			
0.085	+/-0.010	.0845	✓			

Measured by: MH / gmf
Date: 13/10/17

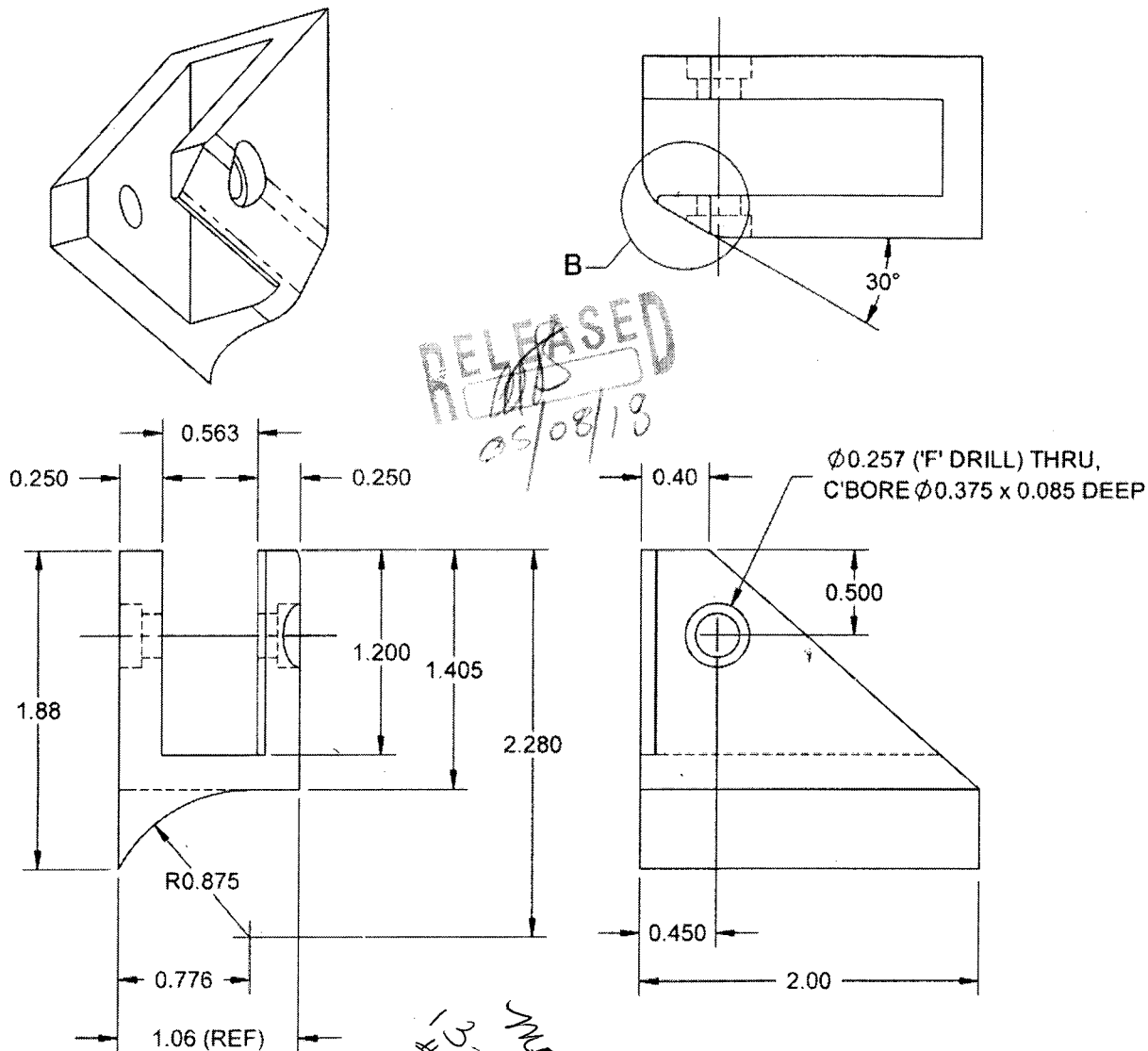
Audited by: (DAS) 40
Date: 13/10/17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	



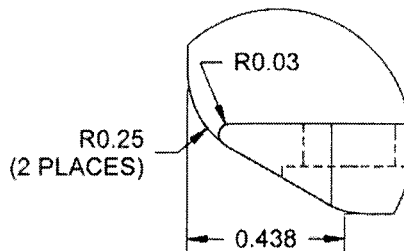
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3440	REV. A SHEET 6 OF 7
DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:1



D3440-13 BRACKET
SUPERSEDES PREMIER P/N B67-43001-273

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL B
SCALE 2:1

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